

QUALITY ASSURANCE PROVISIONS**C-321: SPECIFICATION:**

NSN: 9N5306-01-143-1750 P/N: (78286) 65122-11227-104
NOMEN: BOLT, ECCENTRIC HEAD, PISTON LINK

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65122-11227-104 REV. "J", and all details and specifications referenced therein.

I. Quality/Inspection Requirements

- A. MIL-I-45208, ISO 9000 or equivalent applies:
- B. First Article Testing applies:
- C. Mandatory Inspection applies:

II. Supplemental Requirements

- A. Additionally, para. 3.1-3.5, 5.1-5.2, 6.1-6.2 of MIL-Q-9858 apply.
- B. The contractor shall identify on the process/operation sheets all manufacturing sources performing processes/ operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of First Article or Production Lot Testing without approval from the Engineering Support Activity (ESA) via the PCO.
- C. The Inspection Method Sheets which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging.
- D. Markings should be I/A/W MIL-STD-130 REV. "G" para. 5.3.3(a), (b), (c) and (g). Method and location shall be I/A/W drawing.

III. Mandatory Inspection Requirements:

During production, mandatory inspection is required to be accomplished by the contractor as follows:

- A. Level of Inspection (LOI).
 - 1. Critical Characteristics: 100% inspection shall apply.
 - 2. Major and Minor Characteristics - LOI shall be I/A/W a sampling plan acceptable to the QAR.

B. Critical Characteristics

1. "D" Diameter: .8724/.8729 Before Plating
2. "D" Diameter: .8740/.8730 After Plating
3. .875-14UNJF-3A THD. (MIL-S-8879)
4. Heat Treat: hardness C39-43 at location specified is a critical characteristic.
5. Magnetic Particle Inspection Acceptance per SS 8805 is a critical characteristic.
6. Silver Plate .0003 - .0005 Thick All Over.

C. Major and Minor Characteristics

1. Shall be defined by the contractor subject to QAR concurrence, unless defined on applicable drawings and associated specifications.

IV. Unless expressly provided for elsewhere in this Clause, equipment such as fixtures, jigs, dies, patterns, templates, mylars, special tooling, test equipment, or any other manufacturing aid required for the manufacture and/or testing of the subject item(s) will not be provided by the Government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing or referenced specification.

I-961 FIRST ARTICLE TESTS REQUIRED (GOVERNMENT TESTING)

I. First Article Inspection/Test Criteria:

The tests to be performed under the First Article approval clause of the contract are:

- A. 100% Dimensional Check (special)
- B. Compliance with drawing (78286) 65122-11227-104REV. "C", and specifications referenced therein.
- C. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Article(s) to be delivered hereunder shall also be subjected to those tests which will demonstrate that the article(s) comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article Sample(s) during testing.

II. Samples to be submitted for testing:

- 1 each before plating
- 1 each after plating

A. Waiver of First Article Testing Requirements may be granted for (78286) Sikorsky Aircraft .

III. Testing shall be performed at the Government designated facility listed below.

Naval Aviation Depot
Attn: Annie Thomas, Code 6.1.523
PSC Box 8021
MCAS Cherry Point, NC 28533-5030

IV. Special Instructions

A. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to ready for issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant QAR. Sample(s) may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Sample(s), the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the PCO, Attn: 02____. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR. Upon shipment of First Article Sample(s), two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to PCO with duplicate copies to NAVICP Code 0731 and to the designated test facility. The envelopes shall be clearly marked. "DO NOT OPEN IN MAILROOM".

Within __ days after receipt of sample(s) the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to NAVICP Code 02____.

C-330

PRODUCTION LOT TESTING REQUIREMENTS

NSN: 5306-01-143-1750, P/N: (78286) 65122-11227-104

NOMEN: BOLT, ECCENTRIC PISTON LINK, BLADE FOLD

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

I. Production Lot Test Requirements

- A. The cognizant CAO/QAR shall select 2 items at random from the first produced.
- B. Production Lot Testing to be completed during production after First Article approval.

II. Production Lot Sample Testing Provisions

- A. Compliance with drawing (78286) 65122-11227, REV. "C"
- B. Dimensional Check
- C. Review of documentation as provided under CDRL (DD1423)

In addition to the above tests, the Production Lot Samples delivered hereunder shall also be subjected to those tests which will demonstrate that the samples comply with contract requirements.

III. Testing Location, Cost and Estimated Leadtime

- A. Testing may be accomplished at contractor's facility or at the following testing facility:

**Naval Aviation Depot
Attn: A. Thomas, Code 6.3.674
PSC Box 8021, Bldg 137
MCAS Cherry Point, NC 28533-5030**

Within fifteen days of completion of Production Lot Testing, NAVAVNDEPOT, Cherry Point, NC and/or CAO/QAR shall prepare and submit two copies of their test report with conclusions and recommendations to the Contracting Officer and NAVICP-PHIL Code 0733.

IV. NOTIFICATION OF TESTING:

The contractor shall notify the PCO, ACO and QAR prior to conducting Production Lot Tests so that the Government may witness such testing.

- A. The QAR shall be present to witness all Production Lot Tests.

V. Inspection of Samples

A. Upon inspection of Production Lot Samples two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to NAVICP Code 0734, with duplicate copies to NAVAVNDEPOT, Cherry Point, NC, Code 6.1.523 and to the designated test facility. The envelope shall be clearly marked. **"DO NOT OPEN IN MAILROOM"**.

B. Samples may be considered as production items under the contract provided the samples can be refurbished to Ready for Issue (RFI) condition and provided the samples have inspection approval of the cognizant CAO/QAR. Samples may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

CONTRACT DATA REQUIREMENTS LIST

(2 Data Items)

FORM APPROVED
OMB NO. 0704-0188

PUBLIC REPORTING BURDEN FOR THIS COLLECTION OF INFORMATION IS ESTIMATED TO AVERAGE 440 HOURS PER RESPONSE, INCLUDING THE TIME FOR REVIEWING INSTRUCTIONS, SEARCHING EXISTING DATA SOURCES, GATHERING AND MAINTAINING THE DATA NEEDED AND COMPLETING AND REVIEWING THE COLLECTION OF INFORMATION. SEND COMMENTS REGARDING THIS BURDEN ESTIMATE OR ANY OTHER ASPECT OF THIS COLLECTION OF INFORMATION, INCLUDING SUGGESTIONS FOR REDUCING THIS BURDEN TO DEPT. OF DEFENSE, WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA. 22202-4302, AND TO THE OFFICE OF MANAGEMENT AND BUDGET, PAPERWORK REDUCTION PROJECT (0704-0188), WASH. DC 20503. PLEASE **DO NOT RETURN** YOUR FORM TO EITHER OF THESE ADDRESSES. SEND COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PR NO. LISTED IN BLOCK E.

CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY: TDP TM OTHER		
D.SYSTEM/ITEM 9Z 5306-01-143-1750		E. CONTRACT/PR. NO.		F. CONTRACTOR		
1. DATA ITEM NO. 1		2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT		3. SUBTITLE COMPLETE PROCESS OP SHEETS		
4. AUTHORITY (Data acquisition document No) DI-MISC-80678/T1		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP/CHPT		
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK 16*	14. DISTRIBUTION		
8. APP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK 16*	a. ADDRESSEE	b. COPIES Draft Final Reg Repro	
16. REMARKS PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 SHALL APPLY * UPON SUBMISSION OF FIRST ARTICLE TESTING SAMPLE ** IF PROCESS OPERATION SHEETS CHANGE AFTER SUCCESSFUL COMPLETION OF F.A.T.				NADEP/CHPT		
				CODE 3.3.2	*	1/0
				DCMC/QAR	**	1/0
				NAVICP-P/0734		1/0
1. DATA ITEM NO. 2		2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT		3. SUBTITLE COMPLETE INSPECTION METHOD SHTS		
4. AUTHORITY (Data acquisition document No) DI-MISC-80678/T2		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP/CHPT		
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK 16*	14. DISTRIBUTION		
8. APP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK 16*	a. ADDRESSEE	b. COPIES Draft Final Reg Repro	
16. REMARKS PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 SHALL APPLY * UPON SUBMISSION OF FIRST ARTICLE TESTING SAMPLE ** AT TIME OF CONTRACT COMPLETION				NADEP/CHPT		
				CODE 3.3.2	*	1/0
				DCMC/QAR	**	1/0
				NAVICP-P/0734		1/0
G. PREPARED BY 0731.13		H. DATE		I. APPROVED BY		
				J. DATE		

